

shp April 20

Work Order ID 82225

82225

Page 1

March-27-12 7:43:43 AM

Item ID: D4314-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 27/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4314	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4314

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

6061 -128

AB / Jm 120404 (15)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

AB / Jm 120404 (15)

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 120404

(14)

7707

W/O:		82225 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4314-1 PAR #: _____ Fault Category: Small Feb / water Jet NCR: Yes No DQA: OK Date: 12/04/14
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: OK Date: 12/4/14

NCR:		5.81 WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/14	100	Qty +1 one Part Found with Percin from water Jet in middle of Part E.C. machine malfunction	S Q57042	SCRAP + Destroy Qty +1 no Rep're extra made	B 12-4-4	S 12/04/14	S 12/04/14 Q57042	S 12/04/14

NOTE: Date & initial all entries

Work Order ID 82225

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Page 2

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 27/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

COUNTER SINK AS PER DWG

EP 12/04/04

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sizkaly

(114)

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Ae 12.04.04

(x14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82225

March-27-12 7:43:43 AM

82225

Page 3

Item ID: D4314-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 27/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 20/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC3- Inspect Part Finish 0.00

170

QC

Memo

0.00

Quality Control

14X2 M/L 12/04/05

180 Identify as per dwg & Stock Location: SB9C 0.00

180

Packaging

Memo

0.00

Packaging

100 Sp 12-04-05

190 QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

12/4/10
ME
12-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-27-12 7:43:47 AM

Page 1

Work Order ID: 82225

82225

Parent Item: D4314-1

D4314-1

Parent Item Name: Shim

Start Date: 27/03/2012

Required Date: 20/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	82.2900	0.019	0.2	5		

M6061T6S 125

6061-T6 .125 Sheet

**

Location	Loc Qty	Loc Code
MAT021	82.29	
113608	46.69	
118217	0.09	
119513	10.8	
120218	24.71	

120218 RB/Jm 120404 15

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

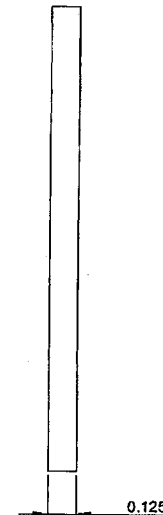
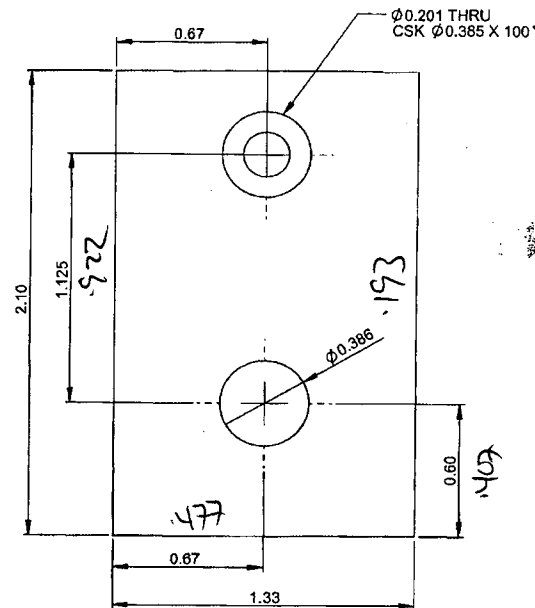
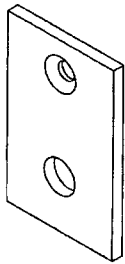
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D4314-1 SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82225 MLC
12/03/27

RELEASED
2011-02-11
MP

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)
OR
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	SC	11.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4314	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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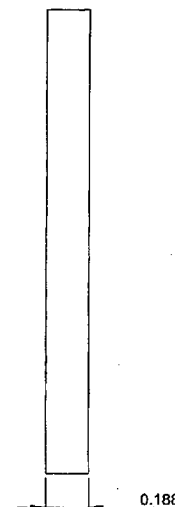
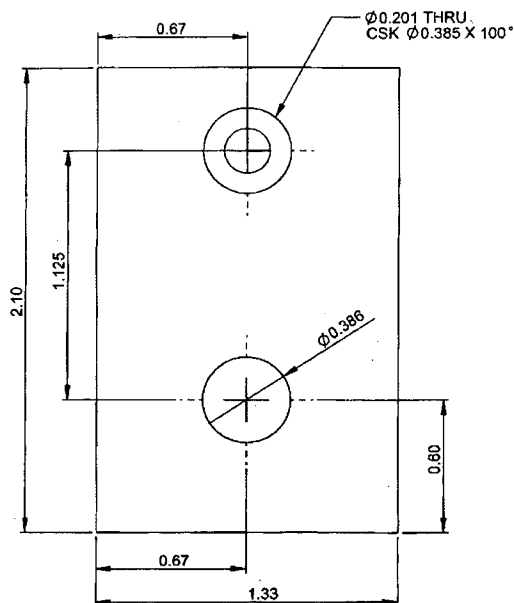
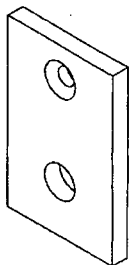
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4314-3 SHIM

RELEASED
2011-02-01
MP

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188) OR ALUMINUM 6061-T6-T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	D4314	SHEET 2 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SHIM	NTS
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